

# Work Order ID 116369

\*116369\*

Page 1

Monday, April 14, 2014 9:28:50 AM

Item ID: D350-588-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Aft Door Assembly  
 Start Date: 4/14/2014 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 5/23/2014 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: CL Date: 14/04/14 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2445/D350-588	Rev D/D								

100 Document Control 0.00 DAS  
 \*100\* DOCUMENT CONTROL 06  
 DC Memo 0.00 9-89 JUN 04 2014  
 Doc.Control -USB or Paperwork Photocopy bluefile and create labels per PPP D350-588-041 CHG003

110 PURCHASING 0.00  
 \*110\* Purchasing 0.00  
 Purchasing Memo  
 Issue P/O: 23807  
 Description: D2445 Baggage Door  
 Supplier: Delastek  
 Ship to Delastek (1) D0588-041 label  
 Certification of Conformity and process sheet from Delastek is required.

MLJ 14-05-30

CL 14/04/15 ①

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Item ID: D350-588-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Aft Door Assembly  
 Start Date: 4/14/2014 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 5/23/2014 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs  Memo Ensure Certificate of Conformity & Process Sheet are attached	0.00  0.00							<i>P44/p22 (1)</i>
130 <b>*130*</b> QC Quality Control	QC6- Inspect dimensions to drawing  Memo Inspect as per Dwg D2445. Audit process sheet.	0.00  0.00		DAS 27 9-89 <i>14/5/22</i>					
140 <b>*140*</b> Small Fab Small Fab Small Fab	Small Fab  Memo Assemble all of the above parts as per Dwg D350-588	0.00  0.00							<i>1</i> <i>CL/9-06-03</i>

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Item ID: D350-588-041

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Aft Door Assembly

Start Date: 4/14/2014 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 5/23/2014 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

**\*150\***

QC

Memo

0.00

Quality Control

155

Pick Kit

0.00

**\*155\***

Packaging

Memo

0.00

Packaging

DAS  
33  
9-89

14-05-30

DAS  
31  
9-89

160

QC4- 100% Inspect kits for completeness

0.00

**\*160\***

QC

Memo

0.00

Quality Control

JUN 04 2014

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Item ID: D350-588-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Aft Door Assembly

Start Date: 4/14/2014 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 5/23/2014 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <b>031A</b>	0.00							<b>DAS</b>
<b>*170*</b>									<b>06</b>
Packaging	Memo	0.00							<b>9-89</b>
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

JUN 04 2014

**MLJ 1406-04****MLF 14-6-4**

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Work Order ID: 116369

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Parent Item: D350-588-041

\*D350-588-041\*

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/23/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP P 04.02.04ReformatKJ/DS  
per DS19414 DD verified by:EC  
10.03.29 verified by:EC

IPP Rev:Q as  
IPP Rev:R add pick kit DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C1032R7

Purchased

No

155

Each

290.0000

2

2

**\*AN526C1032R7\***

Screw

DAS  
06  
9-89

Location

Loc Qty

Loc Code

ST346

290

128831

8

M126175

32

M128403

250

\*\*

DAS  
33  
9-89

DAS  
31  
9-89

126175

AN526C832R8

Purchased

No

155

Each

351.0000

8

**\*AN526C832R8\***

Screw

DAS  
06  
9-89

Location

Loc Qty

Loc Code

ST345

351

125388

14

m127817

87

m128403

250

\*\*

DAS  
33  
9-89

14-06-04

DAS  
31  
9-89

5 x 127817  
3 x 128403

AN526C832R9

Purchased

No

140

Each

668.0000

8

8

**\*AN526C832R9\***

Screw

Location

Loc Qty

Loc Code

ST345

668

M127363

4

M128403

64

M128429

600

\*\*

DAS  
33  
9-89

14-05-30

128429

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Work Order ID: 116369

**\*116369\***

Parent Item: D350-588-041

**\*D350-588-041\***

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/23/2014

Start Qty: 1.00

Required Qty: 1.00

D2143

Manufactured No

140

Each

22.0000

1

1

DAS  
33  
9-89

**\*D2143\***

Hinge Bracket

\*\*

Location

Loc Qty

Loc Code

ST005

22

100918

12

108818

7

98391

3

100918

D2144

Manufactured No

140

Each

21.0000

1

1

DAS  
33  
9-89

**\*D2144\***

Hinge Doubler

\*\*

14-05-30

Location

Loc Qty

Loc Code

ST005

21

100467

21

100467

D2150

Manufactured No

155

Each

16.0000

2

2

DAS  
33  
9-89

**\*D2150\***

Packer Doubler, Hinge

\*\*

106861

Location

Loc Qty

Loc Code

ST005

16

112962

16

DAS  
31  
9-89

D2151

Manufactured No

155

Each

34.0000

2

2

DAS  
33  
9-89

**\*D2151\***

Packer Doubler

\*\*

114304

14-06-04

Location

Loc Qty

Loc Code

ST005

34

102125

2

106821

32

DAS  
31  
9-89

DAS  
06  
9-89

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Parent Item: D350-588-041

\*D350-588-041\*

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/23/2014

Start Qty: 1.00

Required Qty: 1.00

D2153

Manufactured No

155

Each

60.0000

1

\*D2153\*

Door Prop

\*\*

DAS

33

9-89

Location

Loc Qty

Loc Code

FG

4

85865

4

ST260

56

100934

5

110755

18

114286

33

100934

DAS  
31  
9-89

DAS  
06  
9-89

D2154

Manufactured No

155

Each

11.0000

1

\*D2154\*

Bracket, Stud

\*\*

DAS

33

9-89

Location

Loc Qty

Loc Code

ST006

11

100839

11

100839

DAS  
31  
9-89

DAS  
06  
9-89

D2237

Manufactured No

155

Each

60.0000

2

\*D2237\*

Striker Plate

\*\*

DAS

33

9-89

14-06-04

Location

Loc Qty

Loc Code

ST007

60

108708

20

112911

40

112911

DAS  
31  
9-89

DAS  
06  
9-89

D2445P

Purchased No

110

Each

0.0000

1

1

\*D2445P\*

Aft Door Assembly

\*\*

116369

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**\*116369\***

Parent Item: D350-588-041

**\*D350-588-041\***

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/23/2014

Start Qty: 1.00

Required Qty: 1.00

D2461

Manufactured No

155 f

674.9700 7.25 8

DAS

33

9-89

14-06-04

**\*D2461\***

Seal (Per Foot)

DAS  
06  
9-89

1X 87"

DAS  
27  
9-89

Location

Loc Qty

Loc Code

ST402

674.97

102517

174.97

114238

500

114238

DAS

31

9-89

(D2461-0870) cut (1) at 87.00"

\*\*\*\* per kit\*\*\*\*

D2463

Manufactured No

140 f

341.6337 7.25 8

DAS

33

9-89

**\*D2463\***

1/2" Seal (\$Per Foot) DAS

1X 87"

27  
9-89

Location

Loc Qty

Loc Code

ST402

341.633684

110718

341.633684

110718

(D2463-0870) cut (1) at 87.00"

\*\*\*\* per kit\*\*\*\*

D2585

Manufactured No

140 Each

65.0000 2 2

DAS

33

9-89

14-05-30

**\*D2585\***

Latch Clamp

Location

Loc Qty

Loc Code

ST012

65

108520

1

110344

3

112571

19

112974

14

114114

28

114408

1X 114114

1X CR 14-06-03

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Work Order ID: 116369

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Parent Item: D350-588-041

**\*D350-588-041\***

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/23/2014

Start Qty: 1.00

Required Qty: 1.00

D2586

Manufactured No

140

Each

47.0000

2

2

**\*D2586\***

Door Latch

**\*\***

114985

DAS  
33  
9-89

Location

Loc Qty

Loc Code

FG

13

100607

2

83893

10

95760

1

ST198A

34

108573

24

113641

10

D2589

Manufactured No

155

Each

21.0000

1

1

**\*D2589\***

Keys-Key Chain

**\*\***

14-06-04

DAS  
06  
9-89

Location

Loc Qty

Loc Code

ST012

21

58194

21

58194

DAS  
31  
9-89

D2621

Manufactured No

140

Each

48.0000

2

2

**\*D2621\***

Latch Plate

**\*\***

DAS  
33  
9-89

14-05-30

Location

Loc Qty

Loc Code

FG

2

88616

2

ST013

46

108138

3

115195

43

115195

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**\*116369\***

Parent Item: D350-588-041

**\*D350-588-041\***

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/23/2014

Start Qty: 1.00

Required Qty: 1.00

D2690-17

Manufactured No

155

Each

33.0000

1 1

**\*D2690-17\***

Cable

\*\*

DAS  
33  
9-89

DAS  
06  
9-89

Location

Loc Qty

Loc Code

ST016

33

100752

3

108397

5

110028

6

112206

6

114912

12

94470

1

108397

DAS  
31  
9-89

D2857-1

Manufactured No

140

Each

44.0000

1 1

**\*D2857-1\***

Hinge Bracket

\*\*

DAS  
33  
9-89

14-05-30

Location

Loc Qty

Loc Code

FG

5

82261

4

91914

1

ST019

39

106185

3

110247

12

113744

24

113744

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Work Order ID: 116369

**\*116369\***

Parent Item: D350-588-041

**\*D350-588-041\***

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/23/2014

Start Qty: 1.00

Required Qty: 1.00

D2857-2

Manufactured No

140

Each

52.0000

1

1

**\*D2857-2\***

Hinge Bracket

**\*\***

DAS  
33  
9-89

14-05-30

Location

Loc Qty

Loc Code

FG

3

78904

3

ST019

25

100769

1

108401

24

ST024

24

114154

24

108401

D2858-1

Manufactured No

155

Each

46.0000

1

**\*D2858-1\***

Hinge Bracket

**\*\***

DAS  
33  
9-89

Location

Loc Qty

Loc Code

FG

2

77019

2

ST019

44

100756

8

110032

12

114144

24

110032

D2858-2

Manufactured No

155

Each

44.0000

1

**\*D2858-2\***

Hinge Bracket

**\*\***

DAS  
33  
9-89

14-06-04

Location

Loc Qty

Loc Code

FG

2

77020

2

ST020

42

105555

18

113735

24

105555

DAS  
06  
9-89

DAS  
06  
9-89

DAS  
31  
9-89

DAS  
31  
9-89

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Work Order ID: 116369

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Parent Item: D350-588-041

\*D350-588-041\*

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/23/2014

Start Qty: 1.00

Required Qty: 1.00

FG-778150-550-ROL Purchased

No 155 sf 2,378.000 1

\*FG-778150-550-ROL \*

7781 9oz Glass 50x125yd

68-6  
90  
SVD

Location

Loc Qty

Loc Code

CA	2378
M127570	815
M127701	1563

\*\*

DAS

33

9-89

DAS

31

9-89

127570

CUT ONE SQUARE FEET PER KIT

MS20426AD3-4

Purchased

No 155 Each 7,961.000 12 12

\*MS20426AD3-4\*

RIVET

68-6  
90  
SVD

Location

Loc Qty

Loc Code

MF4	365
125578	365
ST334	3192
m127432	3192
ST509	4404
125578	4404

\*\*

DAS

33

9-89

14-06-04

DAS

31

9-89

125578

MS20470AD4-5

Purchased

No 155 Each 4,029.000 18 18

\*MS20470AD4-5\*

RIVET, UNIVERSAL HEAD

68-6  
90  
SVD

Location

Loc Qty

Loc Code

GA	7
m126926	7
ST336	4022
m126926	716
m128401	1653
m128813	1653

\*\*

DAS

33

9-89

14-06-03

DAS

31

9-89

128813

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Work Order ID: 116369

**\*116369\***

Parent Item: D350-588-041

**\*D350-588-041\***

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/23/2014

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

140

Each

6,190.000

8

8

**\*MS21042L08\***

Nut

**\*\***

DAS  
33

14-05-80

9-89

Location

Loc Qty

Loc Code

ST314

3558

123900

58

m128401

1500

m128429

2000

ST508

2533

125445

1135

m127410

1398

ST509

99

m127304

99

128429

MS21042L08

Purchased

No

155

Each

6,190.000

10

10

**\*MS21042L08\***

Nut

**\*\***

DAS  
33

14-06-03

9-89

Location

Loc Qty

Loc Code

ST314

3558

123900

58

m128401

1500

m128429

2000

ST508

2533

125445

1135

m127410

1398

ST509

99

m127304

99

128429

DAS  
06  
9-89

DAS  
33  
9-89

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Work Order ID: 116369

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Parent Item: D350-588-041

**\*D350-588-041\***

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/23/2014

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

140

Each

8,800.000

2

2

**\*MS21042L3\***

Nut

**\*\***

DAS

33

9-89

14-05-30

Location

Loc Qty

Loc Code

ST314

1845

M127410

804

M127831

41

M128401

1000

ST506

955

123900

955

ST509

6000

M128754

6000

128754

MS21042L3

Purchased

No

155

Each

8,800.000

4

**\*MS21042L3\***

Nut

**\*\***

DAS

33

9-89

14-06-03

Location

Loc Qty

Loc Code

ST314

1845

M127410

804

M127831

41

M128401

1000

ST506

955

123900

955

ST509

6000

M128754

6000

128754

DAS

06

9-89

DAS

31

9-89

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**\*116369\***

Parent Item: D350-588-041

**\*D350-588-041\***

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/23/2014

Start Qty: 1.00

Required Qty: 1.00

MS27039-08-11

Purchased

No

155

Each

544.0000

2

**\*MS27039-08-11\***

SCREW

**\*\***

DAS

33

9-89

14-06-03

DAS  
06  
9-89

Location

Loc Qty

Loc Code

ST307

18

123352

18

ST506

526

122441

37

123185

1

123900

88

M128770

400

122441

DAS  
31  
9-89

MS27039-1-15

Purchased

No

140

Each

1,027.000

2

2

**\*MS27039-1-15\***

Screw

**\*\***

DAS

33

9-89

Location

Loc Qty

Loc Code

ST306

427

124326

427

ST506

600

m127916

600

124326

NAS1149D0363J

Purchased

No

140

Each

5,383.000

2

2

**\*NAS1149D0363.J\***

Washer

**\*\***

DAS

33

9-89

14-05-30

Location

Loc Qty

Loc Code

GA

23

124392

23

ST510a

5360

m126319

130

m127813

230

m128429

5000

128429

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Parent Item: D350-588-041

\*D350-588-041\*

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/23/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

155

Each

5,383.000

2

2

**\*NAS1149D0363J\***

Washer

\*\*

DAS  
33  
9-89

14-06-03

DAS  
06  
9-89

## Location

## Loc Qty

## Loc Code

GA

23

124392

23

ST510a

5360

m126319

130

m127813

230

m128429

5000

128429

NAS1149DN832J

Purchased

No

140

Each

2,506.000

8

8

**\*NAS1149DN832J\***

Washer

\*\*

DAS  
33  
9-89

128948

14-05-30

## Location

## Loc Qty

## Loc Code

MF4

912

M127255

912

ST293

1432

M127813

432

M128429

1000

st510

145

124555

145

ST510a

17

M126319

17

Monday, April 14, 2014 9:28:49 AM

Shop Packet Print

Page 12



# Picklist Print

Monday, April 14, 2014 9:28:49 AM

Page 13

Work Order ID: 116369

\*116369\*

Parent Item: D350-588-041

\*D350-588-041\*

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/23/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN832J

Purchased

No

155

Each

2,506.000

16

16

\*NAS1149DN832J\*

Washer

\*\*

128948

DAS

33

9-89

1406-03

DAS  
06  
9-89

## Location

## Loc Qty

## Loc Code

MF4

912

M127255

912

ST293

1432

M127813

432

M128429

1000

st510

145

124555

145

ST510a

17

M126319

17

DAS

31

9-89

D5080-041X-2

β119725

7.10.

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DAS  
10  
9-89

DAS  
06  
9-89

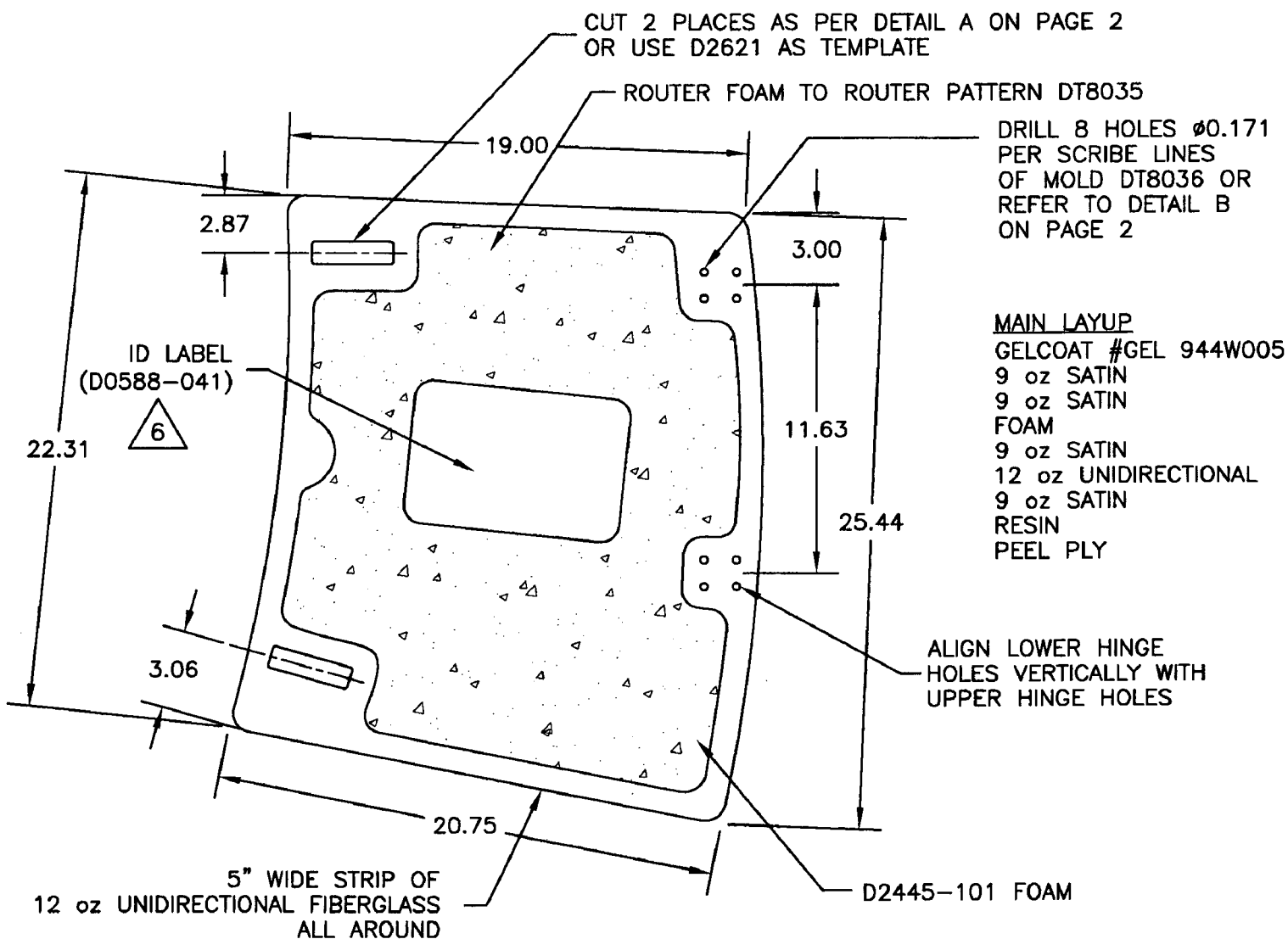
Monday, April 14, 2014 9:28:49 AM

Shop Packet Print

Page 13

**DART**

DESIGN <b>JB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD.</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D2445</b>	REV. D SHEET 1 OF 2
DATE <b>06.06.09</b>		TITLE <b>AFT BAGGAGE DOOR</b>	SCALE <b>1:7</b>
<b>A</b>	<b>97.07.15</b>	<b>NEW ISSUE</b>	
<b>B</b>	<b>02.01.24</b>	<b>ADD D2621; D2445-101</b>	
<b>C</b>	<b>04.02.09</b>	<b>REMOVE D2621; UPDATE NOTES</b>	
<b>D</b>	<b>06.06.09</b>	<b>ADD DIMENSIONS TO PERIMETER</b>	

**RELEASED**06.11.13 *[Signature]***NOTES:**

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DIVINYCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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C214/04/14  
W10: 116369

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											

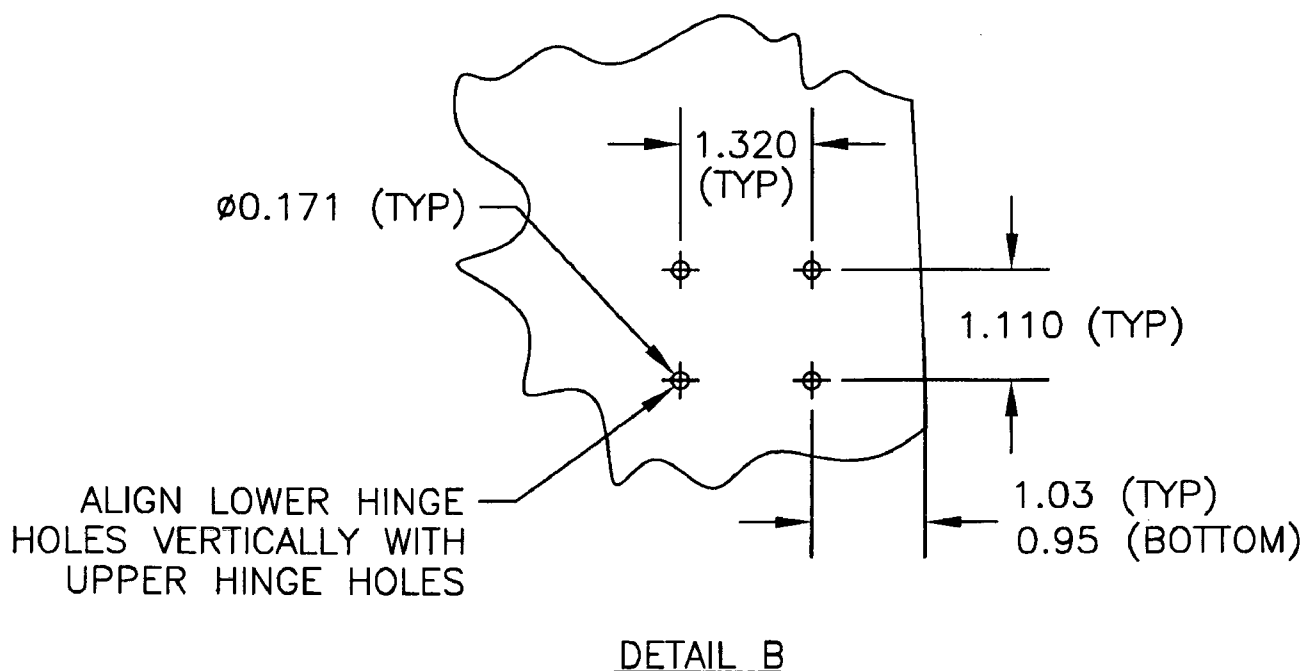
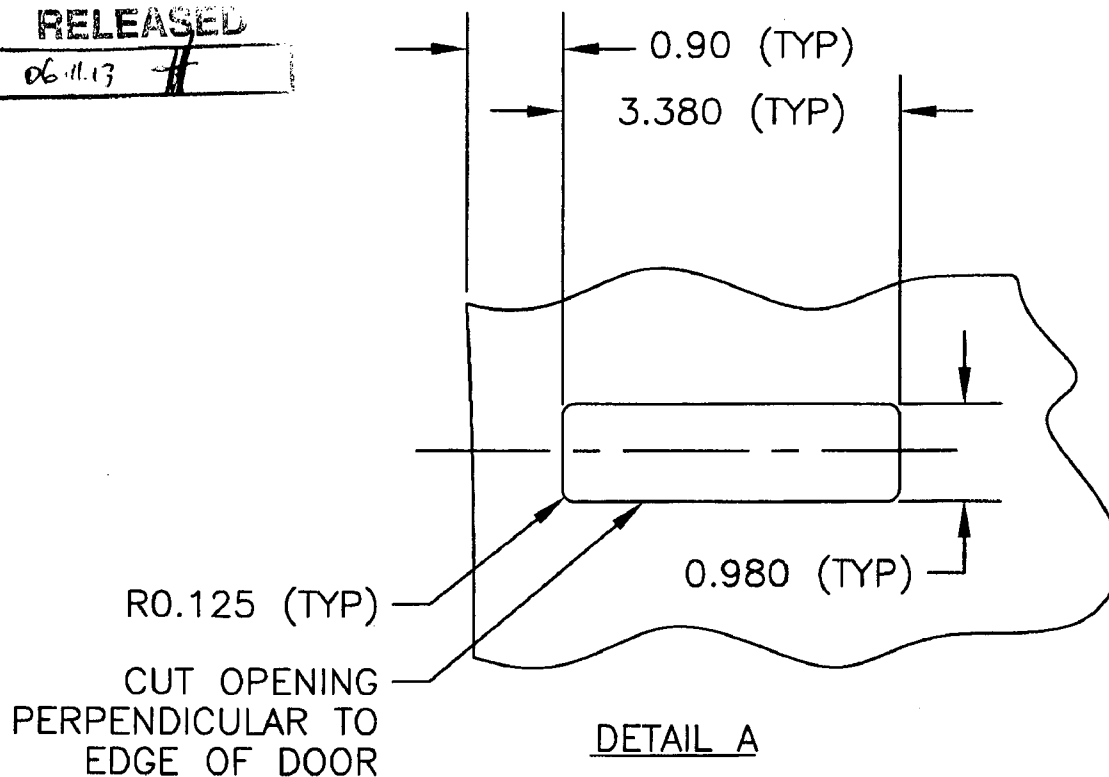
FAULT CATEGORY			
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

**DART**

DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED JB	APPROVED H	DRAWING NO. D2445	REV. - D SHEET 2 OF 2
DATE 06.06.09	TITLE AFT BAGGAGE DOOR		SCALE 1:2

RELEASED

06.11.13



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DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											

FAULT CATEGORY			
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

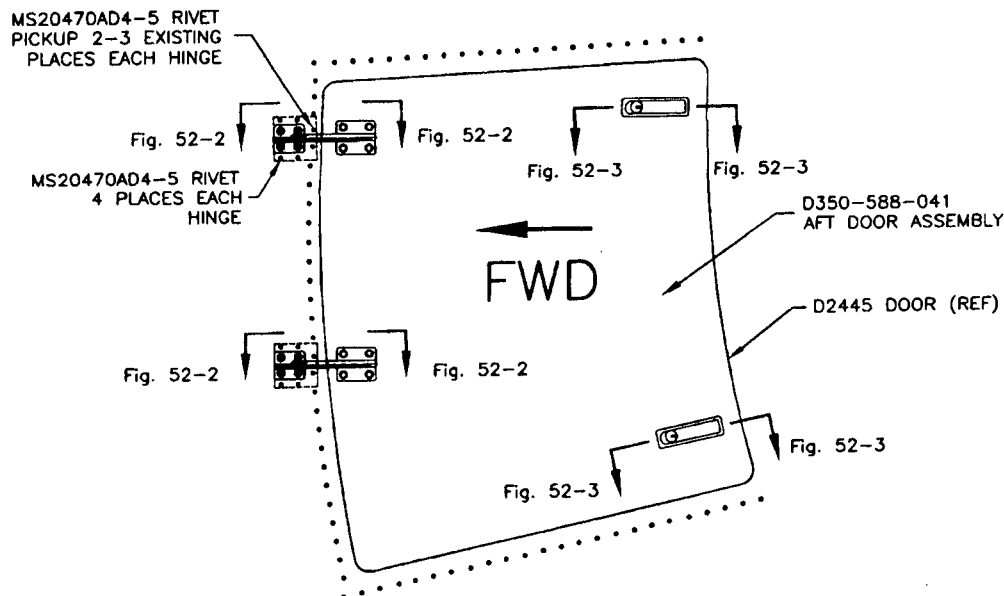


Figure 52-1: Baggage Door Outside View

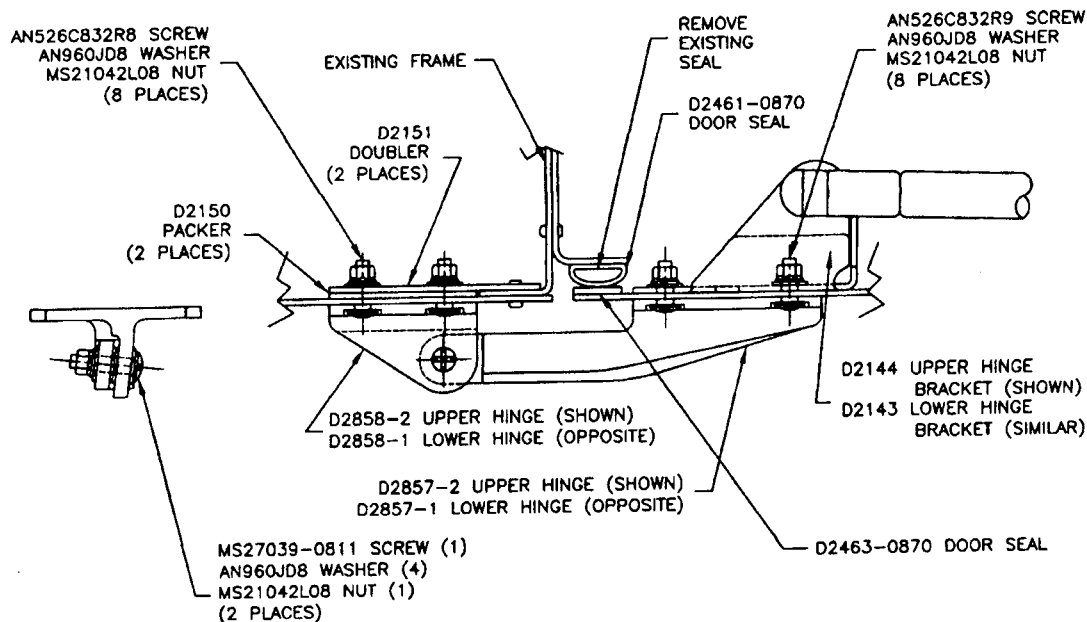
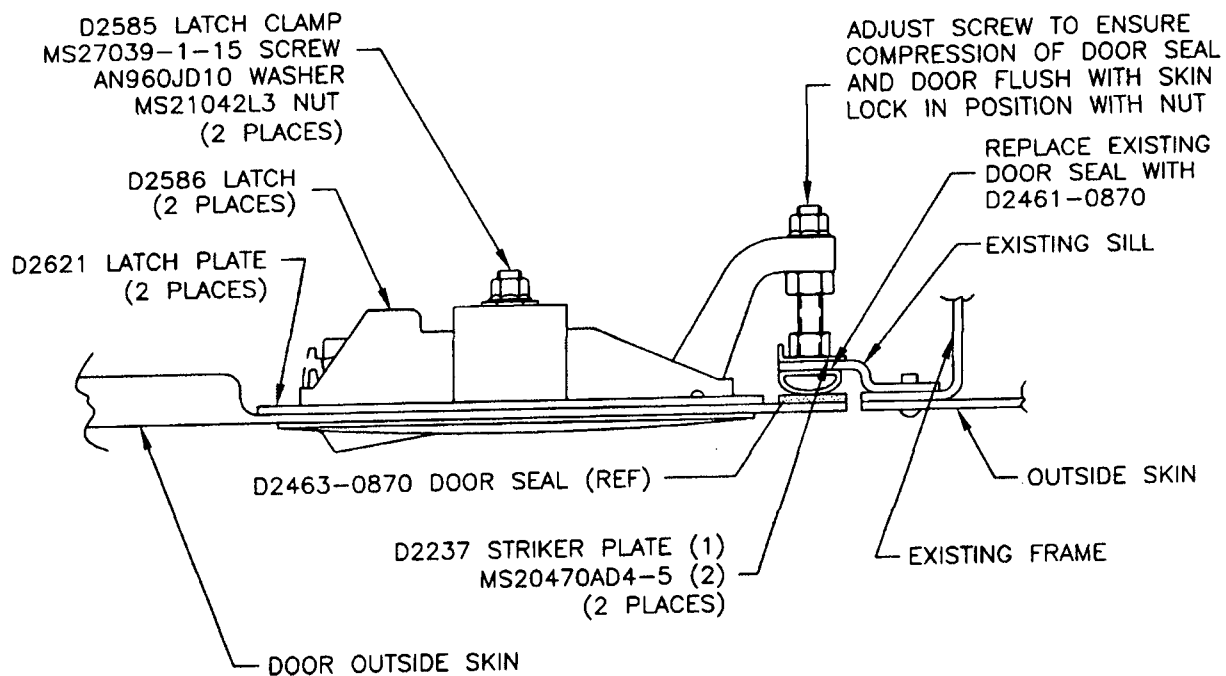


Figure 52-2: Hinge Detail

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52-00-00



**Figure 52-3: Latch Section**

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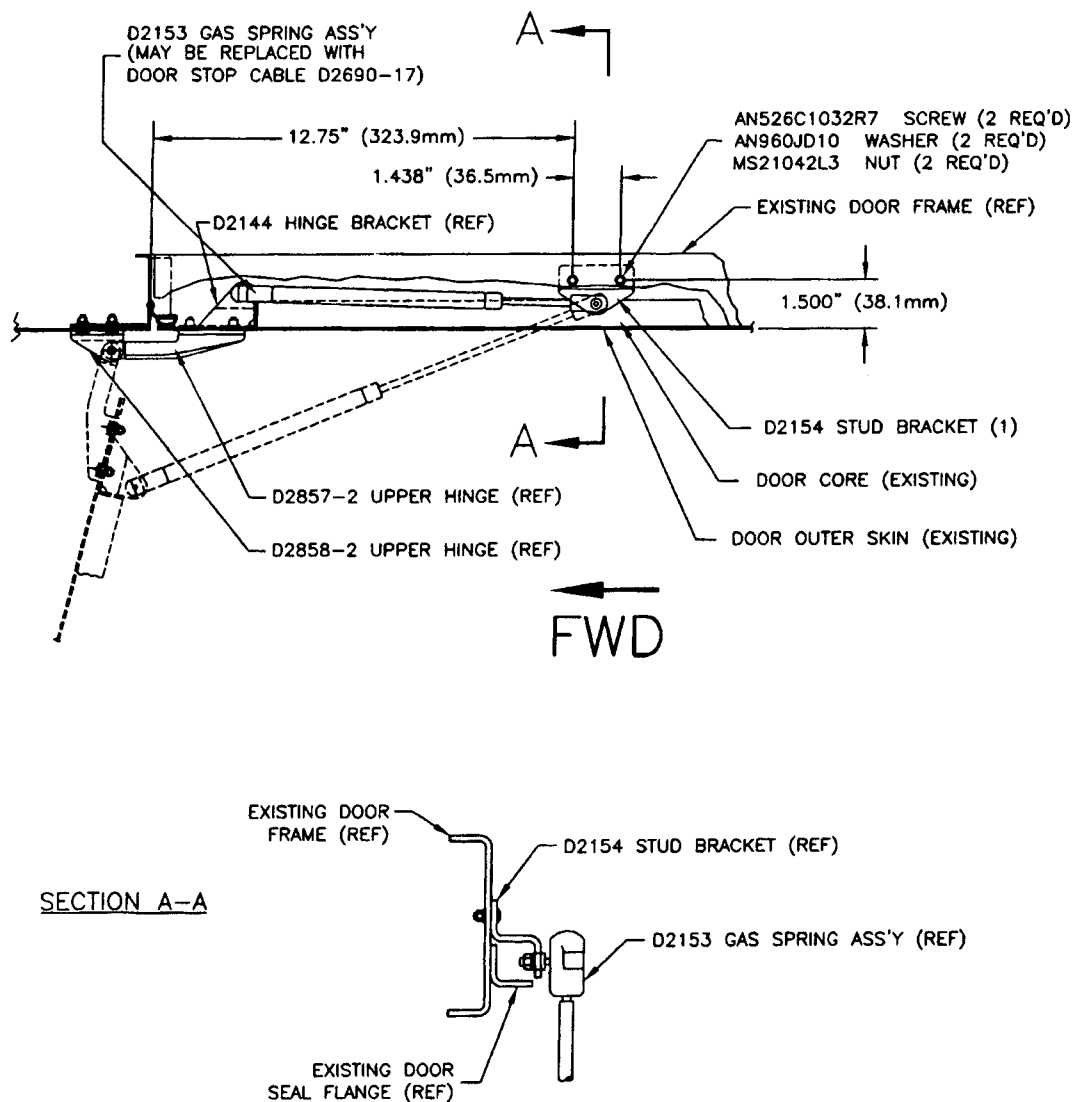


Figure 52-4: Gas Spring Installation

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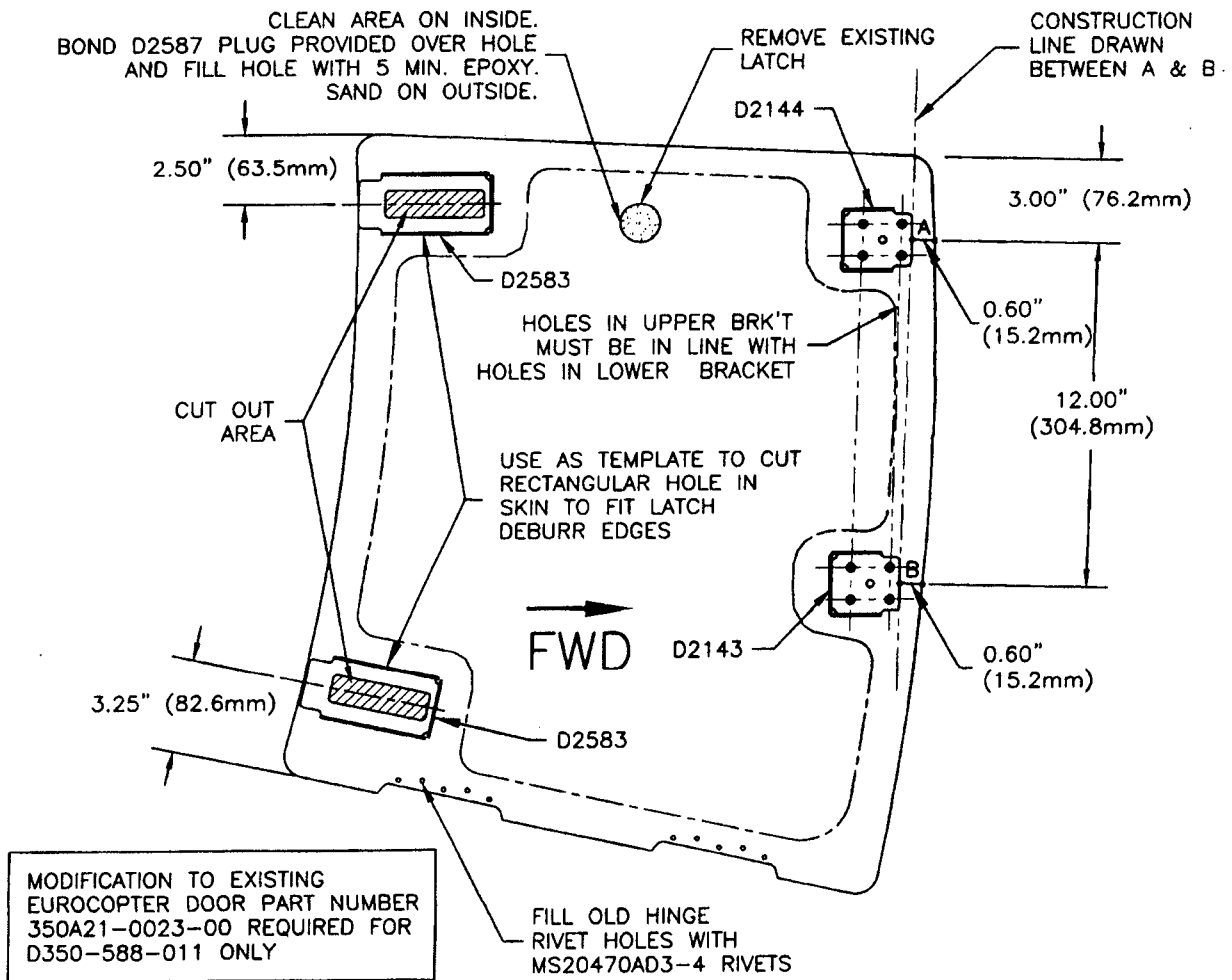
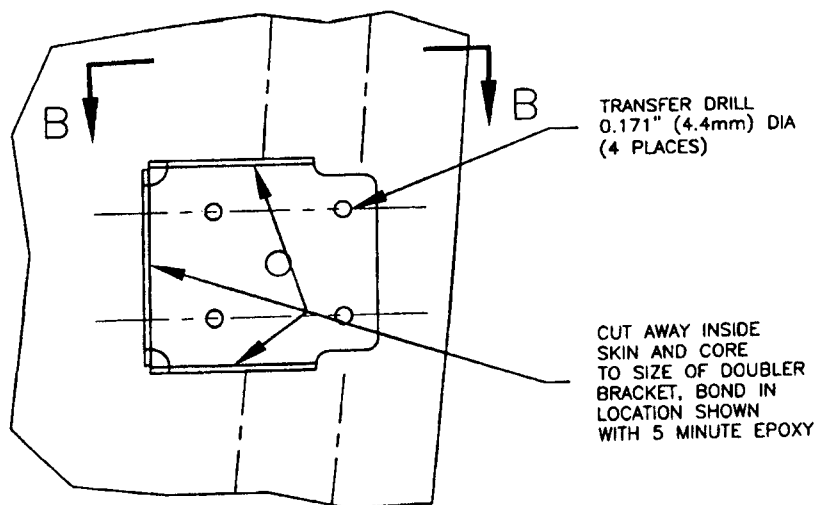
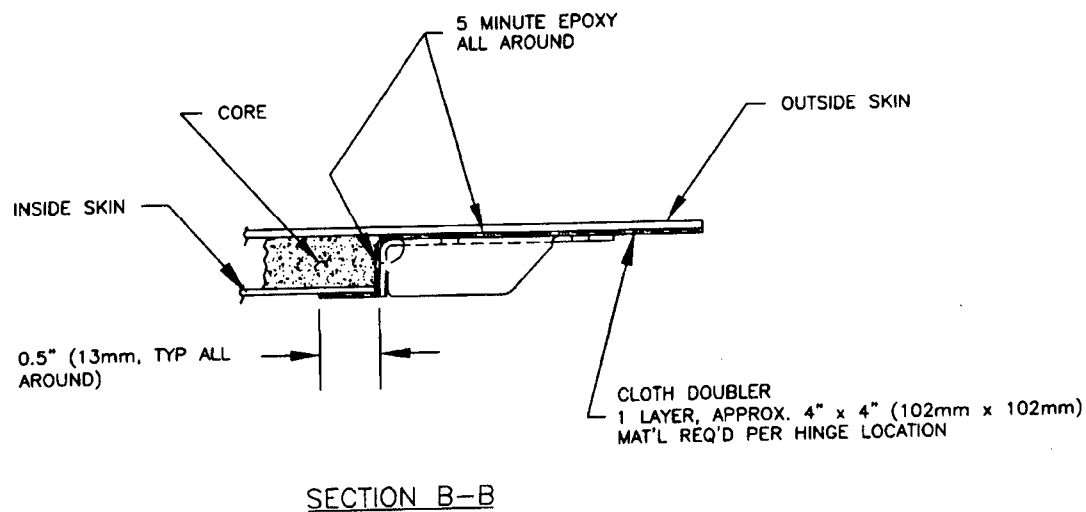


Figure 52-5: Baggage Door Inside View

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**Figure 52-6: Typical Doubler Bracket Installation**

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DELASTEK Inc.  
2699 5e Avenue  
Local 14,  
Grand-Mère, Québec G9T 2P7  
Canada  
Tel.: (819) 533-5788  
Fax: (819) 533-3494

# PACKING SLIP

## CERTIFICATE OF COMPLIANCE

Invoice No.	57335
Customer No.	DART US

### Bill To

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

### Ship To

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
20-05-2014	15-04-2014	24538	Chantal Lavoie	PO23807	Net 30 days USA
Ship Via		F.O.B.		Salesperson	GST/PST
FEDEX P1 Collect		Point de départ		Marie-Pier Montambeault, 235	
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0013	Line #3 Aft Baggage Door (D2445) B116369 U of M: Chaque Drawing N° : D2445 Rév.: D Serial # Lot # B116369 61085	

*It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request*

Accepted by:

Quality department



AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Mercredi, 2014-04-16 08:13:58  
 Utilisateur: marc dubé

## Feuille de Procédé

4/16 Avril

 Client : DART US DART AEROSPACE  
 Numéro Job : 61085  
 Numéro : 3959  
 Numéro B.A. :  
 Cette fois : 2014-04-16 No. :  
 Prsht Rev. : NC  
 Prem. fois : - - Type :  
 Job précédente : 55240

 Nom Dessin : N° D2445, AFT BAGGAGE DOOR  
 Numéro Article : DKC134-0013  
 Numéro Dessin : D2445  
 Projet Numéro : DK-362  
 Révision dessin : D  
 Matériel : Composite  
 Date Dûe : 2014-05-15 Qté: 1 Ud UNITE

 Écrit par :  
 Vérifié & Approuvé par :  
 Commentaires : N° de pièce Client: N/A


E.O.: N/A

 Feuille de Procédé Rév.: 05 ajout de l'IF134-0007 sur  
 plusieurs séquences, numéro du moule passe de  
 DT-8036 pour DKO-0235, numéro du moule passe de  
 DT-8619 pour DKO-0063, ajouter IF134-0006 pour le  
 taillage

Formulaire d'inspection: N/A

 RAC 2345  
 25 avril 2014  
 IV

B116369

COPIE

## Produit additionnel

Numéro Job:



# Séq.:	Machine ou	Description :
1.0	AAC1616	N° 83634, Frekote Loctite Wolo

 Comment Qty.: 0.200 UNITE(s)/Unit Total: 0.200 UNITE(s)  
 N° 83634, Frekote Loctite Wolo # de Lot: 1-42289-1

2.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule N° DKO-0235 selon IG 0009.

Date: 22/04/14

Sceau:



3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------










 Comment Qty.: 0.200 KILOGRAMME(s)/Unit Total: 0.200 KILOGRAMME(s)  
 Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-45003-2

4.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------

 Comment Qty.: 0.0320 GALLON(s)/Unit Total: 0.0320 GALLON(s)  
 Catalyst N° DDM-9 N° de Lot: 1-27829-1















Date: Mercredi, 2014-04-16 08:13:58  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: N° D2445, AFT BAGGAGE DOOR	
Numéro Job: 61085		Numéro DKC134-0013	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
5.0	PREP-GENERAL	Préparation du matériel	
			
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.			
Date: 22/04/14 Sceau: 			
6.0	GEL COAT	Application du Gel Coat	
			
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire l'application du Gelcoat selon IF134-0007			
Date: 22/04/14 Sceau: 			
7.0	AAC1885	Tissu à délaminer Release ply B	
<b>Comment</b> Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)			
Tissu à délaminer Release ply B # de Lot: N/A			
8.0	AAC1887	Wrightlon 5200 Bleu P3	
<b>Comment</b> Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)			
Wrightlon 5200 Bleu P3 # de Lot: N/A			
9.0	AC0885	Feutre de drainage N° Airweave N 10	
<b>Comment</b> Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)			
10.0	AC0943	Stretchlon 200 poche à vide Vert	
<b>Comment</b> Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)			
11.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish	
<b>Comment</b> Qty.: 2.00 VERGE(s)/Unit Total : 2.00 VERGE(s)			
9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: 1-44353-3			
12.0	AMB0511	N° TG-13-U, Fiberglass 13 oz	
<b>Comment</b> Qty.: 0.33 VERGE(s)/Unit Total : 0.33 VERGE(s)			
N° TG-13-U, Fiberglass 13 oz N° de Lot: 1-36302-1			
13.0	AC0886	Ruban à gommer jaune #: T/AT-200Y	
<b>Comment</b> Qty.: 1.2500 ROULEAU(s)/Unit Total : 1.2500 ROULEAU(s)			
14.0	PREP-GENERAL	Préparation du matériel	
			
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Découper les tissus selon IF134-0007.			
Information de référence pour les tissus::			












Date: Mercredi, 2014-04-16 08:13:58  
Utilisateur: marc dubé

## Feuille de Procédé

<b>Client:</b> DART US DART AEROSPACE	<b>Nom Dessin:</b> N° D2445, AFT BAGGAGE DOOR	
<b>Numéro Job:</b> 61085	<b>Numéro</b> DKC134-0013	
Numéro Job: 		
<b># Séq.:</b>	<b>Machine ou Opération:</b>	<b>Description :</b>
<p>4 plis de tissus de 9.7 oz. 1 pli de 13 oz. pour tout le contour de la pièce par 5" de large. 3 fois le sac à vide Strechlon 200. 3 fois le film perforé P-3 3 fois le feutre de drainage 2 fois le tissu à délaminer ( non nécessaire lors du bagging du core ).</p> <p>Date: 17-04/14 Sceau: </p>		
15.0	AMB0286	Catalyst N° DDM-9
<b>Comment</b>	Qty.: 0.0130 GALLON(s)/Unit Total : 0.0130 GALLON(s) Catalyst N° DDM-9 N° de Lot: 1-27829-1	
16.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
<b>Comment</b>	Qty.: 0.360 KILOGRAMME(s)/Unit Total : 0.360 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-45003-1	
17.0	PREP-GENERAL	Préparation du matériel
 		
<b>Comment</b>	Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs	
<p>Faire la préparation de la résine selon les quantités requise, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350</p> <p>Date: 22/04/14 Sceau: </p>		
18.0	LAMINAGE	Faire le laminage
 		
<b>Comment</b>	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs	
<p>Laminer la pièce selon IF134-0007.</p> <p>Date: 22/04/14 Sceau: </p>		
19.0	BAGGING	Faire le bagging sur la pièce
 		
<b>Comment</b>	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs	
<p>Faire la poche à vide selon IG 0012.</p> <p>Laisser sécher pendant 4 heures minimum.</p> <p>Heure Curing début: 12:25 Heure Curing Fin: 8:00</p> <p>Date: 22/04/14 Sceau: </p>		

Date: Mercredi, 2014-04-16 08:13:58  
Utilisateur: marc dubé

## Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	N° D2445, AFT BAGGAGE DOOR
Numéro Job:	61085	Numéro	DKC134-0013
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
20.0	AMB0286	Catalyst N° DDM-9	
Comment	Qty.: 0.0042 GALLON(s)/Unit Total : 0.0042 GALLON(s) Catalyst N° DDM-9 N° de Lot: 1-27829-1		
21.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment	Qty.: 0.120 KILOGRAMME(s)/Unit Total : 0.120 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: 145003-1		
22.0	PREP-GENERAL	Préparation du matériel	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  Faire la préparation de la résine selon les quantités requise, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core selon IG0105.  Date: 1 Sceau: 		
23.0	AAC1611	Polybond B46F	
Comment	Qty.: 0.045 KIT(s)/Unit Total : 0.045 KIT(s) Polybond B46F N° de Lot: 1-38789-1		
24.0	DKC134-0029	Foam Core N° D2445-101 ( Pour AFT Baggage Door )	
Comment	Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) Foam Core N° D2445-101 ( Pour AFT Baggage Door ) N° de Job: 61094		
25.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  Coller le Foamcore selon IF134-0007.  Date: 23/04/14 Sceau:  		
26.0	BAGGING	Faire le bagging sur la pièce	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  Faire la poche à vide selon IG 0012  Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.  Heure début Curing: 8:15 Heure Fin Curing: 9:30 Date: 23/04/14 Sceau:  4460 R.L.		

Date: Mercredi, 2014-04-16 08:13:58  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE  
Numéro Job: 61085

Nom Dessin: N° D2445, AFT BAGGAGE DOOR  
Numéro DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

27.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.1360 GALLON(s)/Unit Total: 0.1360 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-27829-1

28.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.360 KILOGRAMME(s)/Unit Total: 0.360 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-45003-1

29.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de catalyst  
N° DDM-9 par quantité de résine N° 411-350.

Date: 24/04/14

Sceau:



30.0 LAMINAGE Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage des tissus de verre selon IF134-0007.

Date: 24/04/14

Sceau:



31.0 BAGGING Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012

Laisser sécher pendant 4 heures minimum.

Heure Curing Début: 10:50 Heure Curing Fin: 8:00

Date: 24/04/14

Sceau:



32.0 DÉMOULAGE Démoulage de la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Démouler la pièce en faisant attention aux coins & rebords.

Date: 25/04/14














Sceau:















Date: Mercredi, 2014-04-16 08:13:58  
Utilisateur: marc dubé

## Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	N° D2445, AFT BAGGAGE DOOR
Numéro Job:	61085	Numéro	DKC134-0013
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
33.0	TRIMAGE	Trimage	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs RNC 8345 Tailler la pièce selon IF134-0006. Date: 9/05/14 Sceau: 		
34.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler	
Comment	Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-45373-1		
35.0	FINITION	Finition Générale	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire les réparations de finition s'il y a lieu à l'aide du "Filler" P15-3. Date: 12-05-14 Sceau:  		
36.0	AAC1021	Dupont Primer N° 7704S	
Comment	Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s) Dupont Primer N° 7704S N° de Lot: 1-54556-3		
37.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Comment	Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-44063-3.		
38.0	PRIMER	Application primer	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la préparation et l'application du primer batisseur selon I.G. 0008 Date: 12/05/14 Sceau: 5,10440 # de fiche de mélange: 6588		
39.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler	
Comment	Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-45373-1		
40.0	FINITION	Finition Générale	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire les réparations de finition s'il y a lieu à l'aide du "Filler" P15-3. Date: 13-05-14 Sceau: 		

Date: Mercredi, 2014-04-16 08:13:58  
Utilisateur: marc dubé




## Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: N° D2445, AFT BAGGAGE DOOR	
Numéro Job: 61085		Numéro DKC134-0013	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
41.0	AAC1605	Label N° D0588-041	
Comment	Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) Label N° D0588-041 N° de Lot: <u>1-45570-1</u>		
42.0	AAC1609	Surface Veil	
Comment	Qty.: 0.07 VERGE(s)/Unit Total : 0.07 VERGE(s) Surface Veil N° de Lot: <u>1-45570-1</u> <u>1-44695-1</u>		
43.0	AAC1220	Résine Mia-Poxy 100	
Comment	Qty.: 0.007 GALLON(s)/Unit Total : 0.007 GALLON(s) Résine Mia-Poxy 100 N° de Lot: <u>1-20095-4</u>		
44.0	AAC1221	Durcisseur 95 Pour Résine Mia-Poxy	
Comment	Qty.: 0.007 QUART(s)/Unit Total : 0.007 QUART(s) Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: <u>1-34505-1</u>		
45.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  Coller le label N° D0588-041 selon IG 0111.  Date: <u>13-05-14</u> Sceau: 		
46.0	AAC1021	Dupont Primer N° 7704S	
Comment	Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>1-43178-2</u>		
47.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Comment	Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>1-44063-2</u>		
48.0	PRIMER	Application primer	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  Faire la préparation et l'application du primer final selon I.G. 0008  Date: <u>15/05/14</u> Sceau:  # de fiche de mélange: <u>6602</u>		
49.0	INSPEC FINAL	Inspection finale	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  Faire l'inspection selon le dessin N° D2445.  Date: <u>16/05/14</u> Sceau: 		

Date: Mercredi, 2014-04-16 08:13:58

Utilisateur: marc dubé

## Feuille de Procédé

<b>Client:</b> DART US DART AEROSPACE	<b>Nom Dessin:</b> N° D2445, AFT BAGGAGE DOOR	
<b>Numéro Job:</b> 61085	<b>Numéro</b> DKC134-0013	
Numéro Job: 		
<b># Séq.:</b>	<b>Machine ou Opération:</b>	<b>Description :</b>
50.0	EMBAL / ENTREPO	Emballage & Entreposage
		
<b>Comment</b> Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
Faire l'emballage des pièces selon IG 0057		
Date: 16 MAI 2014 Sceau: 